

Date: Monday, 6/5/2006 7:31:26 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ROD
Job Number : 27338
Estimate Number : 10740
P.O. Number : N/A Part Number : D31341
This Issue : 6/5/2006 S.O. No. : N/A Drawing Number : D3134 REV DE 06.06.05
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : DE
Previous Run : 24681 Material : N/A
Written By : SEE COMMENT BELOW Due Date : 6/20/2006 Qty: 23 Um: Each
Checked & Approved By : 06.06.05 N
Comment : Est. B 02.11.03 Re-format; Add thread KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0250W049 304 SS Seamless Tubing



Comment: Qty.: 0.6563 f(s)/Unit Total: 2.6250 f(s)

304 SS Seamless Tubing

Cut material to length as per template D3134-1T1

Material: AISI 304/316 Annealed SS tubing 0.250 OD x 0.049 wall (M304TR0.250W.049) Batch:

13X M18960

10X M15522

Batch:

Have a lot of waste

Qty 23

ml 06/06/08

2.0 SMALL FAB 1 6.53 SMALL & MEDIUM FAB RESOURCE 1 6.56



Comment: SMALL & MEDIUM FAB RESOURCE 1

Open both ends with Ø0.161 (#20) drill and thread both ends as per Dwg D3134

Deburr rod, no sharp edges.

Bend as per Dwg D3134 using template D3134-1T2

ml 06/06/16 Qty 16

PTO

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Qty 15

P10

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: CA-9

space doc please ml 06/06/23

5.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

ml 06/06/23

Qty 15

U 06.06.23

| W/O: 2 | | WORK ORDER CHANGES | | | | | |
|----------|------|---------------------|----|--------------------------------|-----|---------------------------------|--------------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| 06/06/26 | 1 | Add Dwg. to step 1. | | <i>[Signature]</i> 06.06.27 | | | <i>[Signature]</i> 06.06.26 |
| | | | | | | | |

| NCR: 27338 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|--|--------------------------------|--|--------------------------------|--------------------------------|--------------------------------|--------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 06/06/14 | 2 | Bad Bend on one D3134-1 and Broken 6 drill inside tubing | <i>[Signature]</i> 06/06/17 | Scrap it them (2 scrap) (5) Total Scrap 8 rods | <i>[Signature]</i> 06/06/16 | <i>[Signature]</i> 06.06.21 | <i>[Signature]</i> 06/06/17 | <i>[Signature]</i> 06.06.21 |
| 06/06/21 | 2 | 1 part badly bent. very crooked in straight length. | <i>[Signature]</i> 06/06/21 | Scrap picks tray | M.F. 06.06.21 | <i>[Signature]</i> 06.06.21 | <i>[Signature]</i> 06/06/17 | <i>[Signature]</i> 06.06.21 |
| 06.06.21 | | | | | | | | |

Part No: D3134-1 PAR #: N/A Fault Category: 2nd / 1st MED & small NCR: Yes No DQA: [Signature] Date: 06/06/26
 NOTE: Date & initial all entries QA: N/C Closed: [Signature] Date: 06.06.26

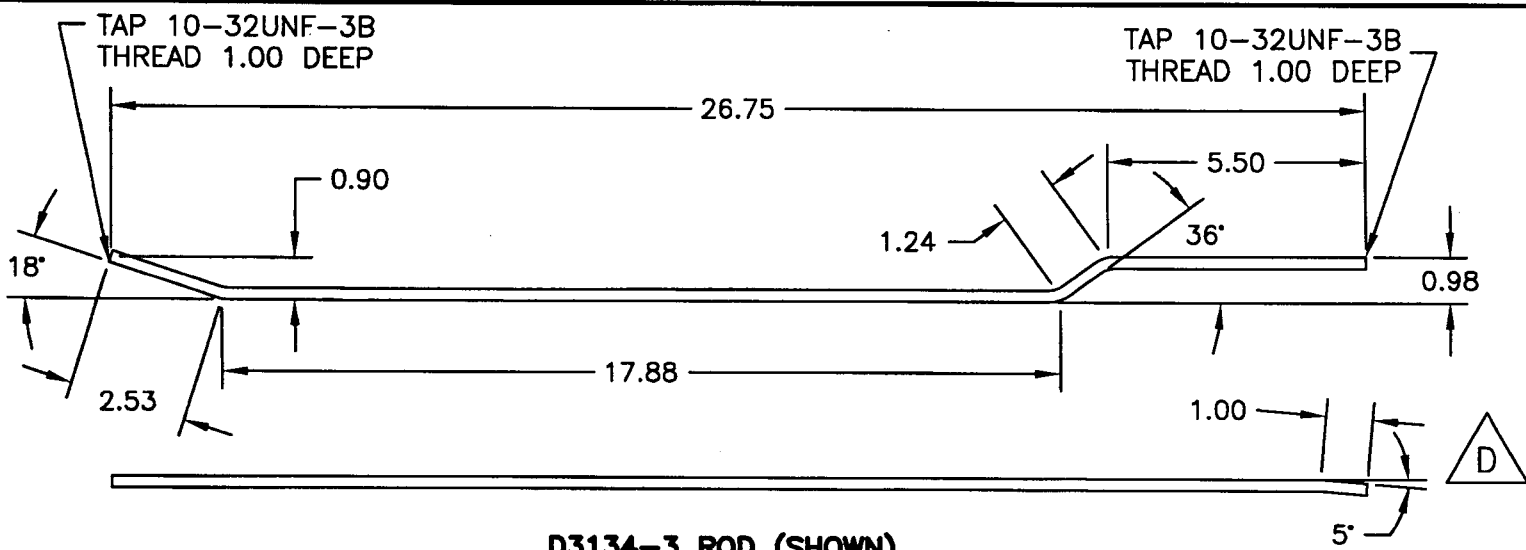
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
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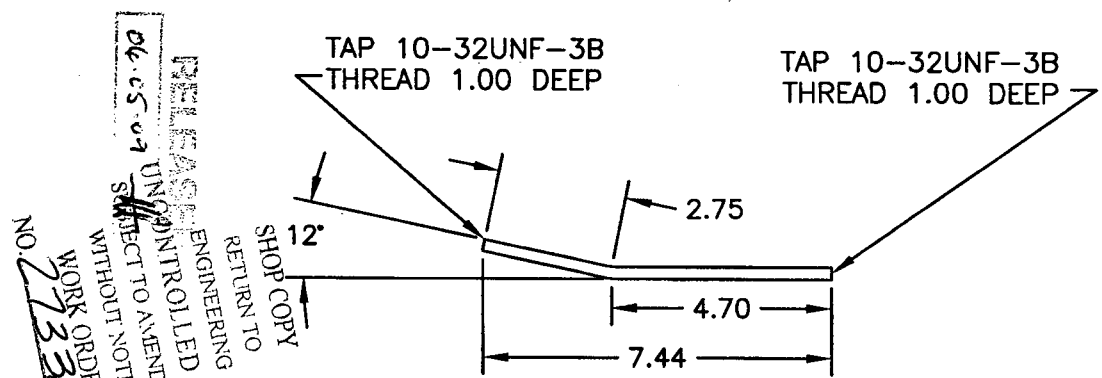
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



D3134-3 ROD (SHOWN)
(REPLACES PREMIER P/N B30-23000-139)
D3134-4 ROD (OPPOSITE)



D3134-1 ROD
(REPLACES PREMIER P/N B30-23000-137)

NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS TUBING 0.250 OD x 0.049 WALL
(REF DART SPEC. M304TR0.250W.049)
- 2) TOOLING: MAKE D3134-1 PER TOOL DT8656
MAKE D3134-3 PER TOOL DT8657
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



| DESIGN | PH | DRAWN BY | PH | DART AEROSPACE LTD |
|---------|----------|--|-------|-----------------------------|
| CHECKED | | APPROVED | | HAWKESBURY, ONTARIO, CANADA |
| DATE | 06.05.08 | DRAWING NO. | D3134 | REV. E |
| | | TITLE | ROD | SHEET 1 OF 2 |
| | | | | SCALE |
| | | | | NTS |
| A | 02.04.17 | NEW ISSUE | | |
| B | 02.09.26 | ADD "ANNEALED" SPEC; REDESIGNED D3134-1 | | |
| C | 04.10.18 | ADD PART MARKING | | |
| D | 05.12.05 | CORRECT VIEW | | |
| E | 06.05.08 | ADD -5, REF DSI 9331 | | |

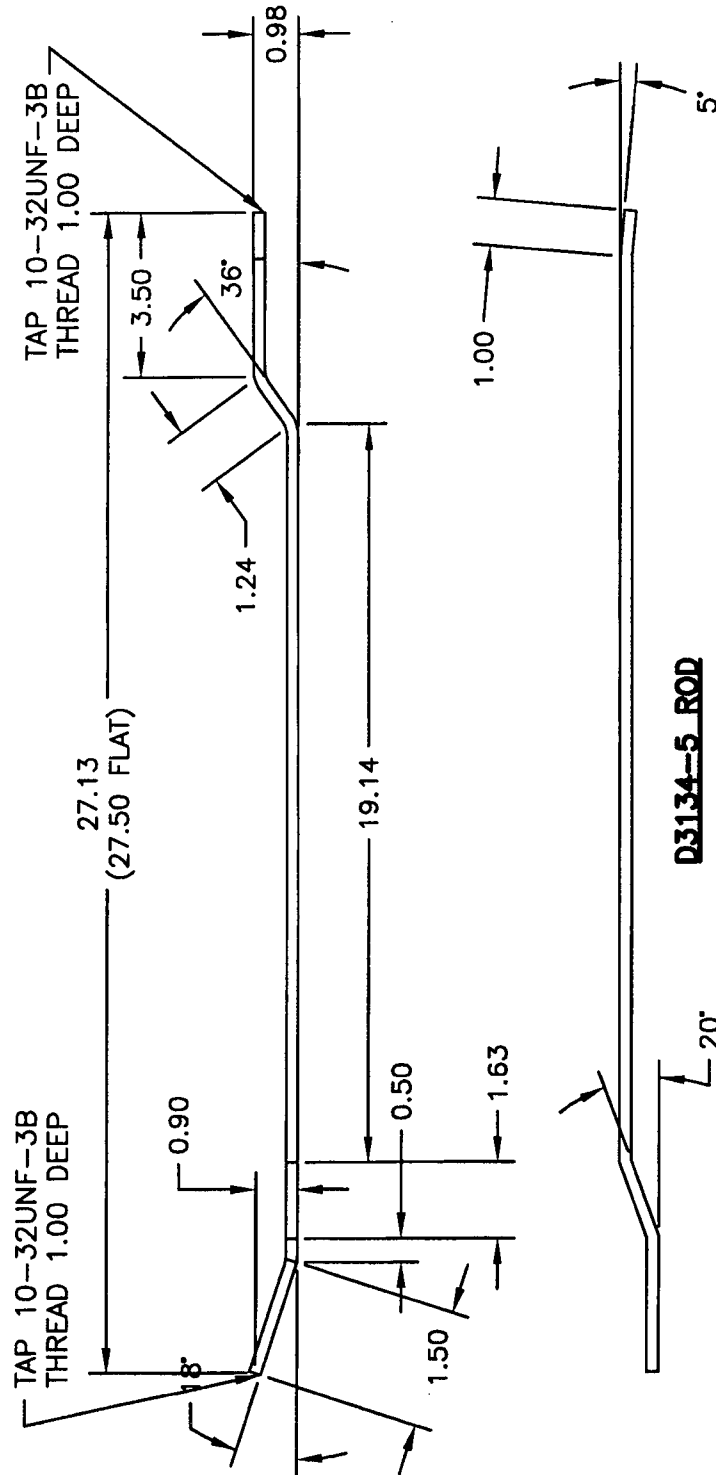
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WORK ORDER
NO. 27338

DART

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|--|---|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED  | APPROVED  | DRAWING NO. D3134 | REV. E SHEET 2 OF 2 |
| DATE 06.05.08 | TITLE ROD | | SCALE NTS |



D3134-5 ROD



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